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HEMMING METHOD

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ABSTRACT

PURPOSE: To bend a hem part without generating recesses by approaching a main hem blade to a panel mounted on a lower die bending the tip of a panel hem part through an edge, then, squeezing the panel hem part rotating the main hem blade with the edge in the center.

CONSTITUTION: An outer panel $P(\text{sub } 0)$ and an inner panel $P(\text{sub } i)$ are mounted on a lower die 20. The hem part of the outer panel $P(\text{sub } 0)$ is bent previously at right angles and a flange part F is formed on the edge part of the inner part $P(\text{sub } i)$. Under this state, a hem part G is bent by a prehem blade to about 45 deg.. Then, an outer slide 21 approaches to the lower die 20 and bends the hem part G by the edge 30. At this time, the inner slide 22 lowers with the outer slide and after bending is executed by the edge 30, the inner slide 22 only lowers, a drive cam 35 comes in contact with a cam surface 34, the main hem blade 26 rotates in the clockwise direction centering the edge 30. Hereby, the hem part G is squeezed.

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